

PTO



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5499-2
Job Sheet 196250



Part No: D5499-2

Job Qty: 6 pcs

Part Name: Aft Bracket Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5499-2 REV.B IPP REV.A NEW ISSUE 18/04/27 JFS VERIFIED BY:DD IPP REV:B 18/08/03 AS PER DWG
REV.B JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 5 Axis	6 pcs	6/28/19	6/28/19	0.50	4.50	HAAS - 5		B.p 19-06-30
120	QC 2	6 pcs	6/28/19	6/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		B.p 19-06-30
							QC 2 - 86		
							QC 2 - 84		



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Container No: S194946



Part: D5499-2

Job No: 196250

Serial No/Batch: S194946

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/30/19

Plex 6/10/19 2:44 PM Dart.lajeunesse.marie

130 QC 8	6 pcs	6/28/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	118 19/7/4
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	6/28/19	0.00 0.50	Handfinish - 1 - 1 - B4B	BEB 19/07/05
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	

150 QC 7	6 pcs	6/28/19	0.00 0.00	Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS
				QC 7 - 50	81
				QC 7 - 67	9-89
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
180 Packaging 3-1 - Stock - B4B	6 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC GA 119
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (HAAS CNC vertical machine #5) 1-Machine per folio FC024. DWG REV: **B** FOLIO REV: **AA** 2-

Descriptions: Deburr and break all sharp edges.

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

180 - (Identify as per dwg & Stock Location: _____)

190 - QC21- Final Inspection - Work Order Release)

cut blank at 4.875

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B3.500X03.500	6061-T6 Bar 3.5" X 3.5" (Cut To 6 ft)	2.4420 ft (.407 ea)	110-HAAS 5 Axis	<i>S/9/233</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-HAAS 5 Axis	M6061T6B3.500X03.500	2	0	0

Part Specifications	
Specifications could not be found.	

*MAT
used
4.970
5.535
5.291*

DART AEROSPACE LTD		Work Order:	196250
Description: AFT BRACKET MOUNT		Part Number:	D5499
Inspection Dwg: D5499	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.33	±.030	.330	—		Vern M/L-08	
.69	±.030	.690	—		"	
R.13	±.030	R.130	—		R-6	
R.13	±.030	R.130	—		"	
1.50	±.030	1.501	—		Vern M/L-08	
2.09	±.030	2.090	—		"	
.623	±.005	.622	—		"	
Ø.191	±.004	Ø.1905	—		"	
1.250	±.010	1.250	—		"	
Ø.257	±.005	Ø.258	—		"	
.80	±.030	.801	—		"	
R.400	±.030	R.400	—		R-6	
R.25	±.030	R.250	—		"	
2.65	±.030	2.648	—		Vern M/L-08	
.623	±.005	.620	—		"	
13X45	±.030 X ±1/8"	.123X45	—		"	
Ø.191	±.004	Ø.1905	—		"	
R.13	±.030	R.125	—		R-6	
.760	±.005	.761	—		Vern M/L-08	
4.66	±.030	4.655	—		"	
2.49	±.030	2.490	—		"	
1.92	±.030	1.922	—		"	
.40	±.030	.400	—		"	
1.245	±.010	1.239	—		"	
1.50	±.030	1.497	—		"	
1.337	±.005	1.340	—		"	
3.506	±.005	3.505	—		"	
.343	±.005					
.80	±.030	.800	—		"	

Measured by: <i>Amf/B.m</i>	Checked by:	QC Inspector:
Date: 19/06/28	Date:	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

mil
July 9, 2019



Entered: _____ Date: _____ WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. 19-7293

Job: 196250
Part No. D5499-2

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☒
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

QTY Affected: 1

Sequence #: 110

Date: 19/06/28

Disposition

Description Work Order Deviation

1 part, drill broke inside the part.

scrap and destroy
replace Qty 1
Batch: 5191233

⇒ Feed and speed of the drill
was corrected in program
B.E 19-06-30

MPS (Q51042)

55
9-89

Completed By
on 19/06/28

Lead hand / Supervisor

B.E 19-06-30

QC / QA Coordinator

40
9-89

JUL 05 2019

Root Cause

Operator ☐
Manufacturing Process ☒
Equipment/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☒
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: